

# Work Order ID 65655

January 21, 2011 10:56:01 AM



Page 1

Item ID: D4185-11	Accept		Setup	Start	
Revision ID: PRELIM				Stop	
Item Name: Idle Stop Limiter					
Start Date: 1/21/11	Start Qty: 2.00				
Required Date: 2/04/11	Req'd Qty: 2.00				
Reference:					

Approvals:	Process Plan: <u>CX</u>	Date: <u>11/01/21</u>	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D4185	PA7 <u>PA2</u> <u>PA3</u> <u>PA4</u> <u>PA5</u> <u>PA6</u> <u>PA7</u> <u>PA8</u> <u>PA9</u> <u>PA10</u> <u>PA11</u> <u>PA12</u> <u>PA13</u> <u>PA14</u> <u>PA15</u> <u>PA16</u> <u>PA17</u> <u>PA18</u> <u>PA19</u> <u>PA20</u> <u>PA21</u> <u>PA22</u> <u>PA23</u> <u>PA24</u> <u>PA25</u> <u>PA26</u> <u>PA27</u> <u>PA28</u> <u>PA29</u> <u>PA30</u> <u>PA31</u> <u>PA32</u> <u>PA33</u> <u>PA34</u> <u>PA35</u> <u>PA36</u> <u>PA37</u> <u>PA38</u> <u>PA39</u> <u>PA40</u> <u>PA41</u> <u>PA42</u> <u>PA43</u> <u>PA44</u> <u>PA45</u> <u>PA46</u> <u>PA47</u> <u>PA48</u> <u>PA49</u> <u>PA50</u> <u>PA51</u> <u>PA52</u> <u>PA53</u> <u>PA54</u> <u>PA55</u> <u>PA56</u> <u>PA57</u> <u>PA58</u> <u>PA59</u> <u>PA60</u> <u>PA61</u> <u>PA62</u> <u>PA63</u> <u>PA64</u> <u>PA65</u> <u>PA66</u> <u>PA67</u> <u>PA68</u> <u>PA69</u> <u>PA70</u> <u>PA71</u> <u>PA72</u> <u>PA73</u> <u>PA74</u> <u>PA75</u> <u>PA76</u> <u>PA77</u> <u>PA78</u> <u>PA79</u> <u>PA80</u> <u>PA81</u> <u>PA82</u> <u>PA83</u> <u>PA84</u> <u>PA85</u> <u>PA86</u> <u>PA87</u> <u>PA88</u> <u>PA89</u> <u>PA90</u> <u>PA91</u> <u>PA92</u> <u>PA93</u> <u>PA94</u> <u>PA95</u> <u>PA96</u> <u>PA97</u> <u>PA98</u> <u>PA99</u> <u>PA100</u>	0.00							
100		0.00							
Bandsaw									
Jeaspa Bandsaw									

110		0.00							
HAAS I									
HAAS CNC vertical machine #1									

MATERIAL CERTIFICATION  
REQ'D UPON DELIVERY



PRELIMINARY ISSUE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 65655**

January 21, 2011 10:56:01 AM

Page 2

Item ID: D4185-11

Accept

Revision ID: PRELIM

Item Name: Idle Stop Limiter

Start Date: 1/21/11 Start Qty: 2.00

Required Date: 2/04/11 Req'd Qty: 2.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

140

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

0.00



Packaging

Memo

0.00

Packaging

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

[illegible]

January 21, 2011 10:56:01 AM

**Accept**

1. The first step in the process is to identify the problem or issue that needs to be addressed. This involves gathering information and understanding the context of the problem.

2. Once the problem is identified, the next step is to define the objectives and goals of the project. This helps to clarify what needs to be achieved and provides a clear direction for the team.

3. The third step is to develop a plan or strategy to address the problem. This involves breaking down the problem into smaller, manageable tasks and determining the resources needed to complete them.

4. The fourth step is to implement the plan. This involves putting the strategy into action and monitoring progress regularly to ensure that the project is on track.

5. The final step is to evaluate the results of the project. This involves assessing whether the objectives have been met and identifying any lessons learned for future projects.

**Setup Start**

[REDACTED]

**Stop**

\_\_\_\_\_

**Cust Item ID:**

1. The first step is to identify the problem or question that needs to be addressed. This involves understanding the context and the specific requirements of the task.

[illegible]

**Customer:**

**Reference:**

Run Start

[REDACTED]

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

**Stop**

1. The first step in the process is to identify the problem or issue that needs to be addressed. This involves gathering information and understanding the context of the problem.

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

### Operation Description

### Set Up/ Run Hours

**Tool ID**

**Tool #****Plan  
Code**

**Accept  
Qty**

Reject Qty

Reject  
Number**Insp.  
Stamp**

150

QC21- Final Inspection - Work Order Release

0.00

[illegible]

QC

## Memo

0.00

### Quality Control

PS 11-06-9  
(2)  
Easle

## POSITIVE RECALL

EFFECTIVE

**AUTH**

RELEASED

DATE \_\_\_\_\_

# PRELIMINARY ISSUE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Page 1

January 21, 2011 10:56:01 AM

Work Order ID: 65655



Parent Item: D4185-11



Parent Item Name: Idle Stop Limiter

Start Date: 1/21/11

Required Date: 2/04/11

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 11-01-20 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDELRLNB0.75X1.250		Purchased	No			100	f	22.7524	0.042	0.088421			



Delrin Bar

Location

Loc Qty

Loc Code

MAT050

22.7524

14535

22.7524

088 *aml 1/22/08*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

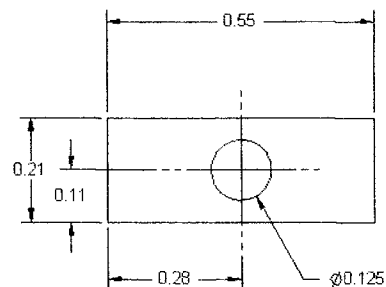
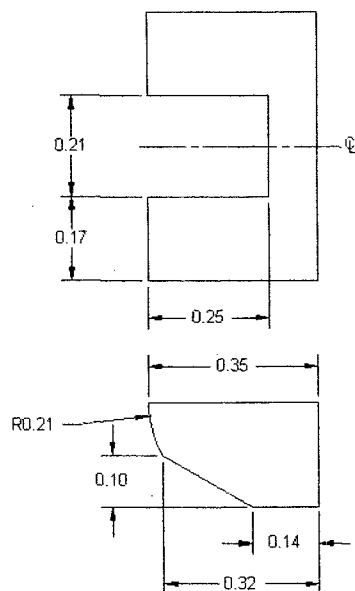
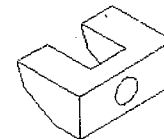
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries







**D4185-11 IDLE STOP LIMITER**

**PRELIMINARY ISSUE**

10.11.12

**NOTES:**

- 1) MATERIAL: BLACK DELRIN II 150E OR ACETRON GP ACETAL  
REF DART SPEC M-DELRIN-B
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.00 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAMKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PA7
MFG. APPR.		<b>D4185</b>	SHEET 7 OF 9
APPROVED		TITLE	SCALE
DE APPR.		<b>INTERNAL BELLCRANK</b>	NTS
DATE	10.11.12	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DRAWING IS THE PROPERTY OF DART AEROSPACE LTD AND IS SUPPLIED ON THE UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

## Receiving Report

Date: 04-03-01  
 Supplier: Cadillac Plastics

Batch No: M 14535  
 Dart P/O: 20066130

Packing Slip: Yes ☒ No ☐  
 Invoice: Yes ☐ No ☒  
 Receipt: Cash ☐ Cr. ☐

Release Note Attached: Yes ☒ No ☐ N/A ☐  
 Waybill Attached: Yes ☒ No ☐  
 Shipment Complete: Yes ☒ No ☐  
 Q.C. Inspection 12/1/03/02

### Discrepancies

Part No.	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments
M-DELRI- R1.2500	Delrin Round Bar 1.25	48	8		40	

TSR No. \_\_\_\_\_

Initials of receiver (if shipment OK) (9)

Production/Admin:  
 Date 04-03-02  
 Received/Costing 26130  
 Initial W

Accounting:  
 Date \_\_\_\_\_  
 AP/MR \_\_\_\_\_  
 Initial \_\_\_\_\_

10

[illegible]

1. *Phragmites australis* (Cav.) Trin. ex Steud.

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[illegible][illegible]

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04-03-01

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100

40/107

1. The first step is to identify the problem or question that needs to be answered. This involves understanding the context and the specific requirements of the task.

# Purchase Order

PO Number 2006130  
Date 02-23-04  
Account # QSI012-6100

Vendor  
Cadillac Plastics(GE Polymer)  
1250 Old Innes Rd. Unit 519  
OTTAWA ONT  
Canada K1B 5L3

Sold To  
Dart Aerospace Ltd.  
1270 Aberdeen St.  
Hawkesbury ON  
Canada K6A 1K7

Ship To  
S A M E

**FAXED**  
04-23-04

Attn PAUL HAMILTON  
Vendor Tel (800) 267-1575  
Vendor Fax (613) 745-4291

Purchaser  
Telephone (613) 632-3336  
Fax (613) 632-4443

Ship Via TRUCK GST # RT101272607 PST # 61225207 OE # 0000WIP  
FOB Point ORIGIN Comments: MATERIAL CERTIFICATION REQUIRED UPON DELIVERY  
Freight Chgs PrePay

Amt	Manuf	Mfg Part No	Our Part Number	Part Description	Delivery	Unit Price	Extended
144.00		<i>Rec'd 04-03-01</i> DELIRIN II 150E OR ACETRON GP GP ACETAL BLACK	M-DELRIN-B0.75x1.250	Delrin Bar	02-27-04	6.6250 /f	954.00
48.00		<i>Rec'd 8</i> DELIRIN II 150E OR ACETRON GP ACETAL BLACK	M-DELRIN-R1.2500	DELRIN ROUND BAR 1.25"	02-27-04	6.2500 /f	300.00

Total Value of Purchase Order

\$1,254.00

*u*  
*04.02.23*